



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3529-1**Job Sheet 199290****Part No:** D3529-1**Job Qty:** 18 pcs**Part Name:** Bearpaw**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/16/19**Job Tracking No:****Due Date:** 8/30/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV A IPP Rev:A New Issue 06-06-28 JLM IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	18 pcs	8/30/19		0.00	0.00	Purchasing - 1		AUG 21 2019
							Purchasing - 2		
							Purchasing - 3		
100	Packaging 2-1 - Receive - B4B	18 pcs	8/30/19		0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S207792**Part:** D3529-1**Job No:** 199290**Serial No/Batch:** S207792**Revision:** A**Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 08/21/19

				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
105	QC 6	18 pcs	8/30/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
120	HAAS 4 Axis - B4B	18 pcs	8/30/19	1.00 21.18	HAAS - 1 - B4B
					HAAS - 2 - B4B
					HAAS - 3 - B4B
					HAAS - 4 - B4B
130	QC 2	18 pcs	8/30/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48

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8/16/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	DJA 19-10-30
						QC 2 - 69	
140	QC 8	18	8/30/19	0.00	0.00	QC 8 - 12	
		pcs				QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	SBL 19/11/01
150	Packaging 3-1 - Stock - B4B	18	8/30/19	0.00	0.00	Packaging 3 - 1 - B4B	
		pcs				Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	DAS 28 89
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 -	

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				B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	18	8/30/19	0.00	0.00
	pcs				
				QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	8-89
				QC 21 - SA - 53	

ST463

NOV 14 2019

Part Op 90 - 1-Issue PO; _____ 2-Cut blanks as per D3529-1_4X8 file.

Descriptions: 100 - Receive & Inspect for Damage & Mat'l Certs.

105 - QC6- All purchased or subcontracted products

120 - (HAAS CNC Vertical Machine), 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA645 and Dwg D3529

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3529-1P	Bearpaw	18 Ea (1 ea)	90-Purchasing	
MCMWB10		27sf (1.5sf each)	DAS 35 8-89	5208791
				S154152

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D3529-1P	18	0	0

Part Specifications
Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 199290
Description: Bearpaw		Part Number: D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

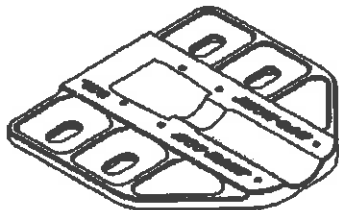
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.500	✓		Vern.	
B	0.07 x 45°	+/-0.030 x 0.5°	0.07 x 45°	✓		Vern.	
C	R0.25	+/-0.030	0.250	✓		R.G.	Radius
D	0.250	+/-0.010	0.253	✓		D.T.-Mic.	
E	0.625	+/-0.010	0.628	✓		Vern.	
F	0.950	+/-0.010	0.960	✓		Vern.	
G	1.63	+/-0.030	1.632	✓		Vern.	
H	12.14	+/-0.030	12.140	✓		Tape	(REF)
I							
J	5.70	+/-0.030	5.700	✓		Tape	(REF)
K	0.375	+/-0.010	0.385	✓		Vern. →	D.T.-Micr
L	0.525	+/-0.010	0.526	✓		D.T.-Mic	
M	0.13 x 45°	+/-0.030 x 0.5°	0.140 x 45°	✓		Vern.	
N	R0.50	+/-0.030	0.500	✓		R.G.	
O	12.76	+/-0.030	12.760	✓		Tape	(REF)
P	3.38	+/-0.030	3.380	✓		Vern.	
Q	3.75	+/-0.030	3.750	✓		Vern.	
R	5.187	+/-0.010	5.187	✓		Vern.	
S	5.25	+/-0.030	5.250	✓		Vern.	
T	7.13	+/-0.030	7.130	✓		Vern.	
U	Ø0.260	+0.006/-0.001	0.259	✓		Vern.	
V	0.30	+/-0.030	0.315	✓		Vern.	
W	0.93	+/-0.030	0.934	✓		Vern.	
X	1.30	+/-0.030	1.30	✓		Vern.	

Measured by: DSP	Audited by: DAS 57	Prototype Approval:	N/A
Date: 19-10-30	Date: 9-89 19/11/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

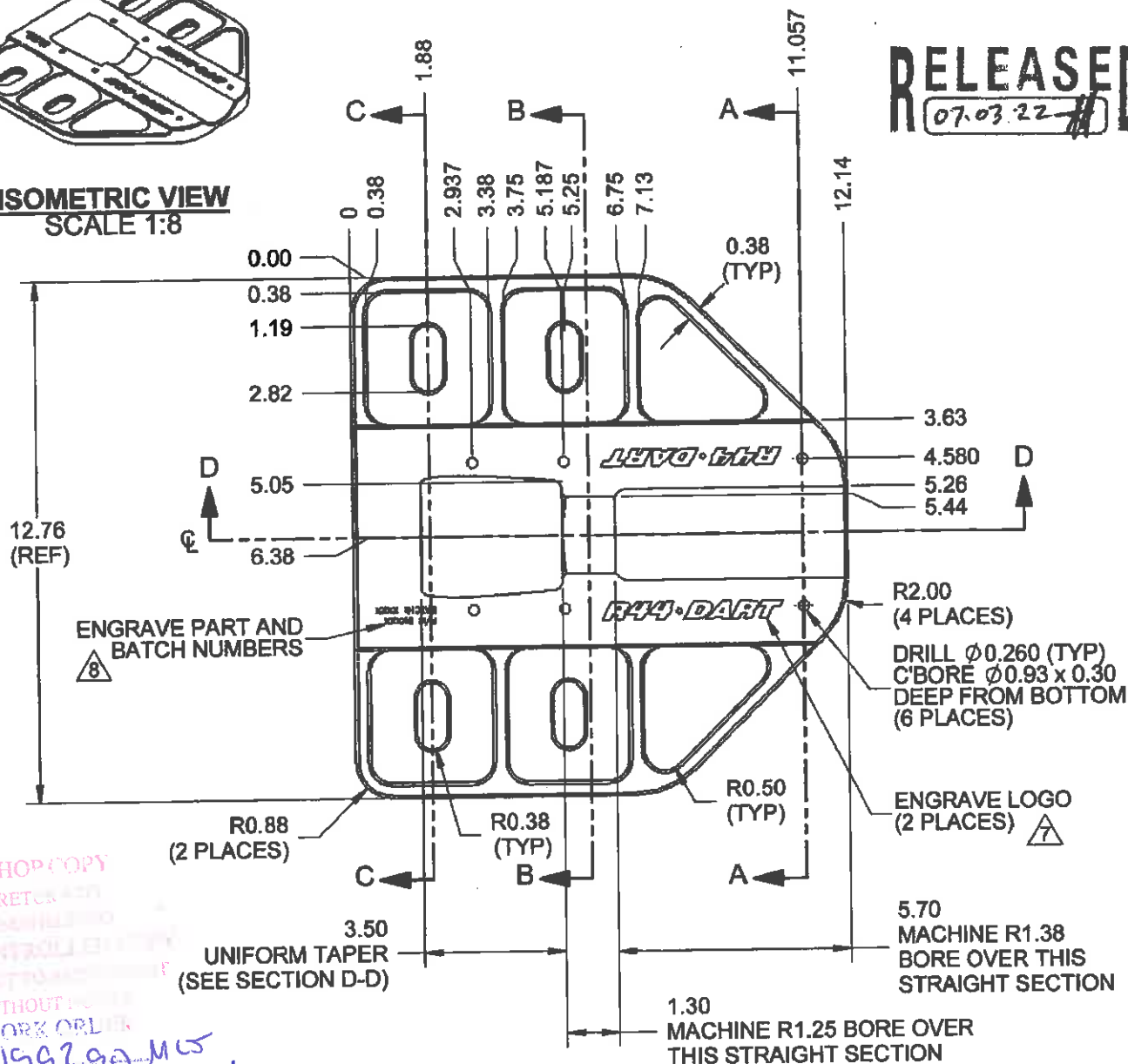
DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8

RELEASED
07.03.22



D3529-1 R44 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework Scrap Use-as-is		Cross tube Small Fab Finishing	
		Skid-tube Machining Large Fab		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	
Date: _____		Sequence #: _____		QTY Affected: _____	
Description Work Order Deviation		Disposition		MRB (QS1042)	
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	

Root Cause		FAULT CATEGORY									
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong			
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance			
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing			
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish			
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing			
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread			
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up					
Human Factors		Other/Details:									



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044289



Supplier: ACI002-VC
Acier Duval Steel
5888 Country Road 17
Plantagenet
ON
K0B 1L0 Canada
Phone: 613-673-5474
Fax: 613-673-4576

PO No: POHB044289

PO Date: 8/19/19

Due Date: 8/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dart.aero

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30

Freight Terms:

Special Comments:

EMAILED
2019-08-20

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
①	199292	D2521P		Individual Bearpaw as per Dwg D2521_Blank File	Firmed	-	8/26/19	20 Ea	0 Ea	20 Ea	\$57.77/Ea	\$1,155.40
						20	X	AUG 21 2019				
②	199291	D3075-1P		Bearpaw (Foot Print Only), as per Dwg D3075_blanknest file	Firmed	-	8/26/19	10 Ea	0 Ea	10 Ea	\$19.97/Ea	\$199.70
						10	X	AUG 21 2019				
③	199290	D3529-1P		Bearpaw as per Dwg F3529-1_4x8 file	Firmed	-	8/26/19	18 Ea	0 Ea	18 Ea	\$23.37/Ea	\$420.66
						18	X	AUG 21 2019				
④	199293	D2432P		Bearpaw 19" X 24", as per DWG D2432_nest7 file	Firmed	-	8/26/19	8 Ea	0 Ea	8 Ea	\$35.26/Ea	\$282.08
						8	X	AUG 21 2019				

Grand Total: \$2,057.84

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance - NOT SUPPLIED

A041 quality management system

A042 dart notification by supplier

A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

A.D.S.

Acier Duval Steel

Fabrication shop: aluminum and stainless steel
plate cutting, bending, rolling and punching services.

Atelier de fabrication: aluminium et acier inoxydable
Service de coupage, pliage, roulage et poinçonnage.

1-866-831-5722

T: 813-673-4574

info@adsindustries.com

5888 County Rd. 17

Plantagenet, ON.

K0B 1L0

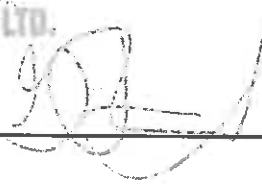
Packing Slip:

S024

Aug 21, 2019

1 of 1

Sold to:	Ship to:
Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No: POH5AM255 ✓	Sold By:
Shipped By:	Ship date:
Tracking No:	

Item No	Quantity	Description
Water jet cutting	20 ✓	Waterjet cutting only, customer material UNMW 1" black : Individual Bearpaw as per Dwg D2521_Blank file, Job 199292 ✓ Part#D3021P ✓
Water jet cutting	10 ✓	Waterjet cutting only, customer material UNMW 1" black: Bearpaw (Foot Print Only) as per Dwg D3075_Markings file. Job 199294, Part#D3075-1P ✓
Water jet cutting	15 ✓	Waterjet cutting only, customer material UNMW 1" black: Bearpaw as per Dwg F3026_4x8 file, Job 199290 ✓ Part#D3026-1P ✓
Water jet Cutting	8 ✓	Waterjet cutting only, customer material UNMW 1" black: Bearpaw 19" x 24" as per Dwg D2412_foot file, Job 199293 ✓ Part#D2412P ✓
RECEIVED AUG 21 2019 DART AEROSPACE LTD. 		
Comments: ADS Industries - Facebook & Instagram		

Acier Duval Steel div. JD Welding Inc.

5888 County Road 17, Plantagenet ON. K0B1L0

Tel: 613-673-4574 ~~~ toll free\ sans frais 1-866-831-5722

info@adsindustries.com www.adsindustries.com

Certificate of Conformance (CoC)

Customer Name Dart Aerospace Ltd.

P.O. Number POHB044289

Job Number

199292

199291

199290

199293

Part Number

D2521P

D3075-1P

D3529-1P

D2432P

Quantity

20

10

18

8

Sheet Number (item)

MUHMWB10

MUHMWB10

MUHMWB10

MUHMWB10

Sheet serial number

S170514 & S154152: 5 pcs each

S170514:6pcs & S154152: 4pcs

S170514

S170514

Material thickness

1" Black UHMW

Invoice \ Packing slip # 8024

All technical requirements of the contract are satisfied. Quality and performance are in accordance with the contract, the specifications, and all references and associated contractual drawing and document

I, as a supplier to Dart Aerospace, acknowledge and certify the material covered under this document is produced in accordance with the following:

Supplier Standards Guide ☒

Global Supplier Quality Manual ☒

Product Conformance ☒

*(Acknowledge by marking the boxes)

DAS
81
9-89

Nathalie Duval

Administration

August 21 2019

Signature

Title

Date

This certifies the parts / items / material identified above conform to all applicable drawing and/or specification as evidenced by report or other documentation on file and all other purchase order and quality requirements have been met